

Date: Thursday, 17/07/2008 1:40:03 PM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LOWER BLADE SUPPORT ASSY
Job Number	: 40598		
Estimate Number	: 13472		
P.O. Number	:	Part Number	: PB674300179
This Issue	: 17/07/2008 S.O. No. :	Drawing Number	: B6743001 P.11
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	:	Material	:
Written By	:	Due Date	: 24/07/2008
Checked & Approved By	: <u>MF 08-07-17</u>	Qty:	6 Um: Each
Comment	: Est Rev:A 08-07-17 new issue DD verified by:ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001171	Mounting Plate
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Mounting Plate

batch: B 37610

MF 08-07-17 6

2.0	PB6743001177	Short Support Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Short Support Plate

batch: B 40031

MF 08-07-17 6

3.0	PB6743001179	Short Side Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Short Side Plate

batch: B 40032

MF 08-07-17 6

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: Weld assembly as per dwg PB67-43001

MF 08-07-17 6

5.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

PD 08-07-17

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOWER BLADE SUPPORT ASSY

Job Number: 40598

Part Number: PB674300179

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



5 08/07/21 (x6)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING



N1102316

(6x)

1- put screws in nut plates before powder coating to keep thread clean

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:40  
320°F  
2:10

M-L 08/07/21

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION



FD 08/07/21 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57511



P 8/7/23 (6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



08/08/20

Job Completion



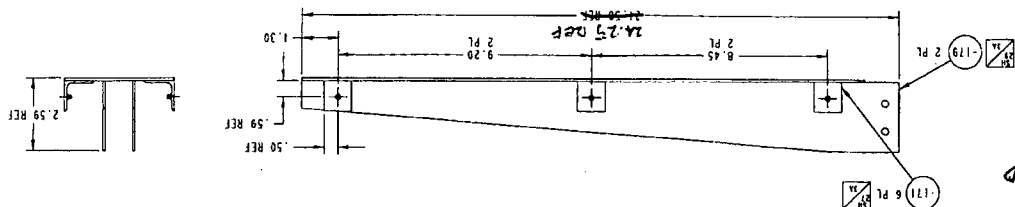
W 28.08.19

**ORIGINAL**

<b>PREMIER AVIATION, INC.</b> 9000 Aviation Parkway, Grand Prairie, Texas 75082					
DATE LOAN (MM/DD) NO.		0 OSUV8		SALES	
B67-43001				11 OF 45	

SCALE 0-500

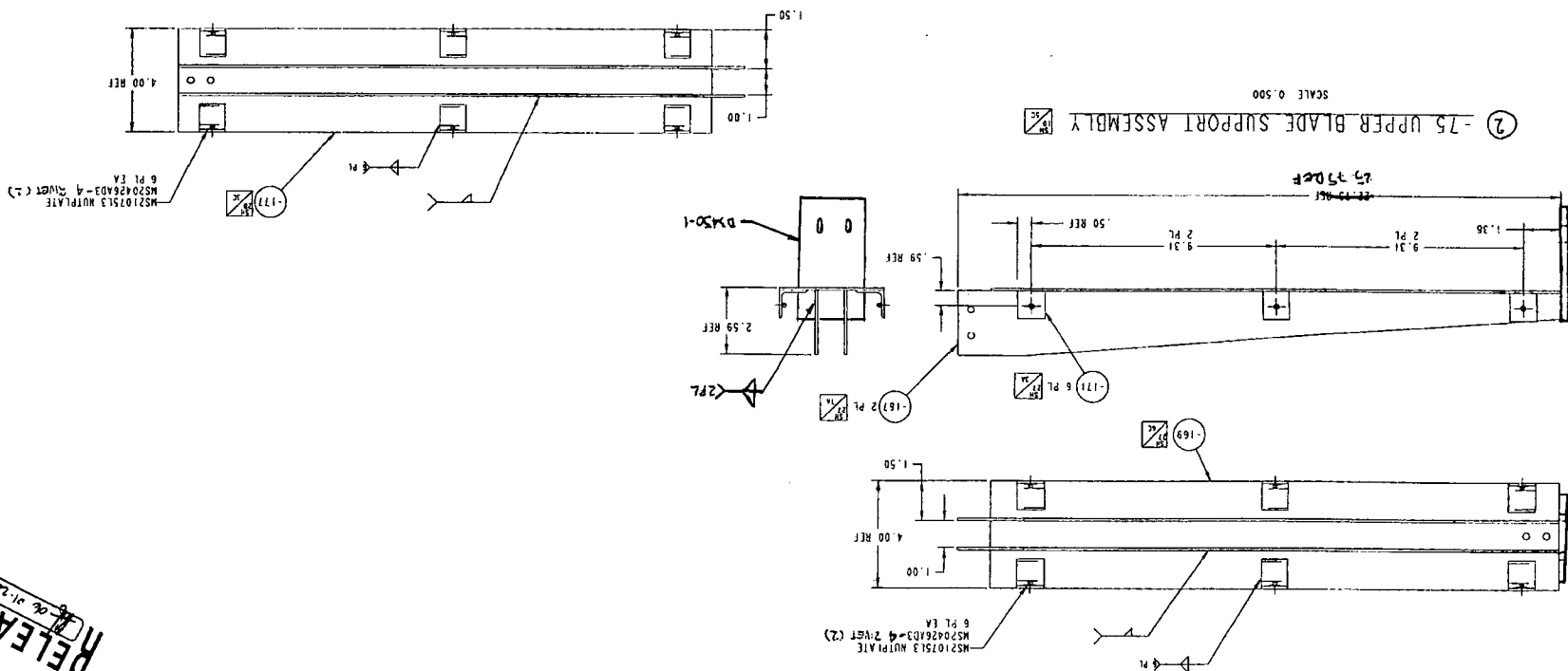
⑦ -79 TOWER BLADE SUPPORT ASSEMBLY



86507 #

SCALE 0.500

② -75 UPPER BLADE SUPPORT ASSEMBLY



DART AEROSPACE LTD		Work Order:	3952
Description: <del>WPA Short Support Plate</del> (-79 Lower Blade Support (LSS))		Part Number:	367-43001-79 ✓
Dwg: 367-43001	SHEET 11	Qty:	10
		Page of	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler			
1 cut	GA	Short Support plate -177 use mat: .090 6061 T6 (m7950) cut part 20.25 x 400 mark & drill holes as per dwg. 2 places center 1/2" in wdg 1.25 in from one end. deburr Batch: 340031		08-06-26	1
2 cut	GA	Short side plate -179 use mat: .125 6061 T6 (m15120) cut 23.50 x 2.50 mark & drill holes as per dwg. cut angle as per dwg. Batch: B40032		08-06-26	2
3 cut	GA	mounting plate -171 use mat: AD10133-1002 6061 T6 20-A-200/8F alt mat: .040 T6, 6061 T6 20-A-250/11 cut 1" x 1" (mat) mark hole center .193 & .098 hole each side for nut plate. Batch: B37670		08-06-26	120
4 install	GA	counter sink holes as per dwg. install nut plate (m521075L3N (m16255) washers (m521426A53-4 (m9748) to mounting plate -171 Batch:		08/07/10	6
5A weld	WA	weld parts -177 & -179 & 171 as per drawing use 1" space (square tube) for gap between side plate -179		08-07-17	12
6 chem	CP	chemical conversion QSI 0054.1			
7- paint	FP	powder coat green sinter AS PER DART QSI 0054.3			
8	QC3	Inspect Powder Coat			
9	ST	Inspection: Start			
5B	QC9	QC9 PD 08-07-17			
5B	QC9	QC9 PD 08-07-17			

Rev	Date	Change	Revised By	Approved

PRELIMINARY ISSUE